

Date: Friday, 6/26/2007 8:16:49 AM
User: Kim Johnston

Process Sheet

Split 1

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : SPACER

Job Number : 32585

Estimate Number : 10383

P.O. Number : N/A

This Issue : 5/25/2007

S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A

Previous Run : 31834

Type : SMALL / MED FAB

Part Number : D30661

Drawing Number : D3066 REV.B

Project Number : N/A

Drawing Revision : B

Material : N/A

Due Date : 6/10/2007

Qty: 50 Unit: Each

Written By : 07.05.28Checked & Approved By : 07.05.28

Comment :

Est.C 02-11-01 Incorporated D3066-1 IPP KJ/RF

Est Rev.B Now M6061-T6 06-06-23 JLM

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S080

6061-T6 .080 Sheet

Comment: Qty.: 0.0992 sf(s)/Unit Total : 5.9535 sf(s)

Material: 6061-T6 0.080" thick

(M6061T6S.080)

Batch: M104186

Remaining Mat = 8.5 ^{39 (ft)}

SAD 07/06/06

2.0

WATER JET

FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3066

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

SAD 07/06/06

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Date: Friday, 5/25/2007 8:16:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 32585

Part Number: D30661

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

R.M

07.06.22

5

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA 25*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.06.22
(5)
07/06/22

Job Completion



U 07.06.22

| | | |
|-----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 32585 |
| Description: Spacer | Part Number: | D3066-1 |
| Inspection Dwg: D3066 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

Prototype

[illegible]

| | | | | | |
|--------------|----------|-------------|-------------|---------------------|-----|
| Measured by: | SAY | Audited by: | [Signature] | Prototype Approval: | N/A |
| Date: | 07/06/06 | Date: | 07-06-11 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-------------------------|------------|----------|
| A | 03.09.22 | New Issue P/O D3065-041 | KJ/RF | |
| B | 06.06.23 | Dwg Rev. changed | KJ/JLM | |

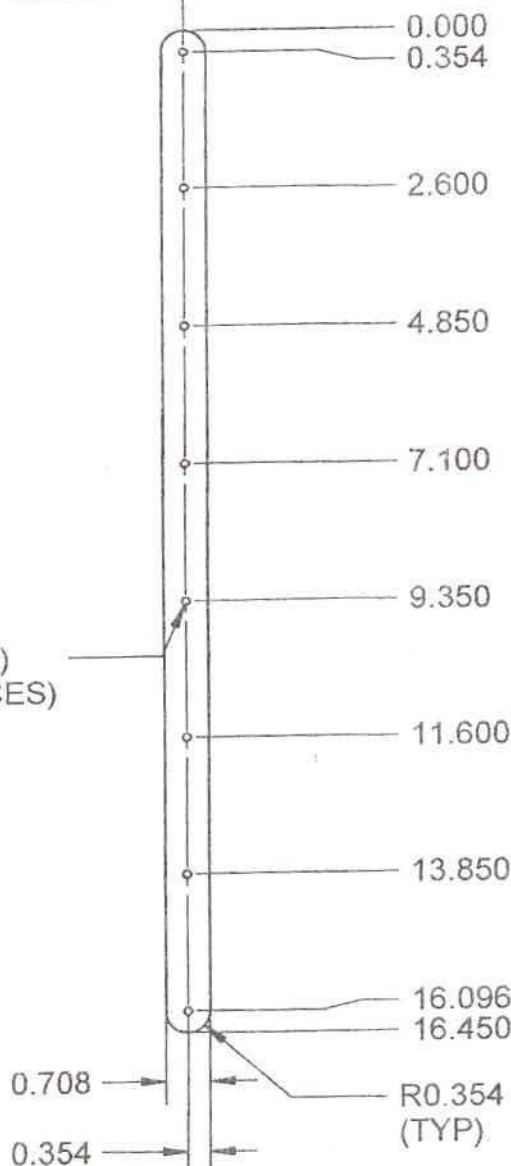


| | | | |
|-------------------------|--------------------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3066 | REV. B SHEET 1 OF 1 |
| DATE 06.05.29 | | TITLE SPACER | SCALE 1:3 |
| A | 02.09.11 | NEW ISSUE | |
| B | 06.05.29 | ADD 6061-T6 MATERIAL | |

RELEASED

06.06.20

$\phi 0.128$ (#30)
(TYP 8 PLACES)



D3066-1 SPACER

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHO/COPY
REF TO
UNCONTROLLED
SUBJ. TO A & B
VER. 32585

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